



NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
2. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART MUST GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REF. ONLY

* TOLERANCE DETERMINED BY VENDOR FOR E BEAM WELD OR VACUUM BRAZING REQUIREMENT

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED LOG NUMBER ALL DIMENSIONS ARE IN INCHES TOLERANCES DECIMALS ANGULAR X .03 (.7620) .25 ° XX .01 (.254) .01 XXX .005 (.127) SURFACE FINISH 125 ✓ REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1 FINISHING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5				
A2090000		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
DRAWN BY FUHRMANN		DATE 6/9/94	CHIEF DESIGN ENGINEER D. SHU	DATE 10/13/94
CHECKED BY J. WOTHE		DATE 10/12/94	GP LEADER T.M. KUZAY	DATE 10/13/94
DESIGNER D.SHU/FUHRMANN		PROJECT MGR.		
RESPONSIBLE ENGINEER D. SHU		DATE 10/13/94	APPROVE/D/RELEASED	
MATERIAL 304 STAINLESS STEEL		SCALE HALF SIZE		
DO NOT SCALE DRAWING		DRAWING NUMBER P4105090804-200107-00		